

Work Order ID 60553

Wednesday, July 14, 2010 8:23:34 AM



Page 1

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: AK Date: 10-7-15 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|-------|
| D3838 | Rev A |
|-------|-------|

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: M109213

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: M109213

8- grind bushing weld flush as per dwg D3838

9- deburr hole if necessary

PL 10-07-28

SAD 10-07-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 60553

Wednesday, July 14, 2010 8:23:34 AM

Page 2

Item ID: D3838-042

Accept

Revision ID:




Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/14/2010 Start Qty: 2.00

Required Date: 7/22/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 110  QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | (+2) -042 | | | |
| 120  QC Quality Control | QC9- Inspect visual per QSI004- Fusion Welds Memo | 0.00 0.00 | | | | (2) 1000.29 | | | |
| 130  Packaging Packaging | Identify as per dwg & Stock Location: <u>WA</u> Memo | 0.00 0.00 | | | | (2) | | | |



Cust Item ID:
Customer:

Setup Start

Stop

Run Start

Stop

8 10/07/29

SAD
10-07-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 60553

Wednesday, July 14, 2010 8:23:34 AM

Page 3

Item ID: D3838-042

Accept

Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/14/2010 Start Qty: 2.00

Required Date: 7/22/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

10/07/29 JF

10-7-29

(2)

| W/O: | | WORK ORDER CHANGES | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 14, 2010 8:23:38 AM

Page 1

Work Order ID: 60553

Parent Item: D3838-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| D3759-1 Bushing | | Manufactured | No | | | 100 | Each | 91.0000 | 1 | 2 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | WA | | | 91 | | | | | | |
| | | | | 54072 | | | 9 | | | | | | |
| | | | | 60190 | | | 40 | | | | | | |
| | | | | 60241 | | | 42 | | | | | | |
| M304TS0.750W.065 304 SQ Tube .75x.75x.065W | | Purchased | No | | | 100 | f | 308.0040 | 1.0317 | 2.172 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | MAT | | | 1.4628 | | | | | | |
| | | | | 112398 | | | 0 | | | | | | |
| | | | | 114482 | | | 1.4628 | | | | | | |
| | | | | WA | | | 306.541185 | | | | | | |
| | | | | 114520 | | | 306.541185 | | | | | | |

CPD 10-07-28

2

JAD

10-07-27

2.172

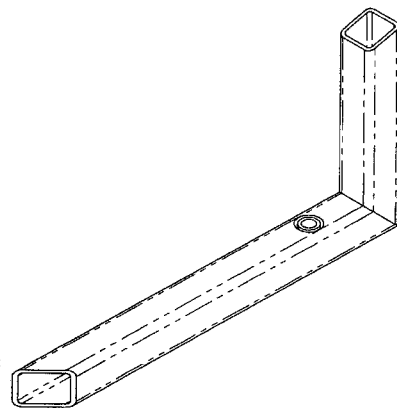
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

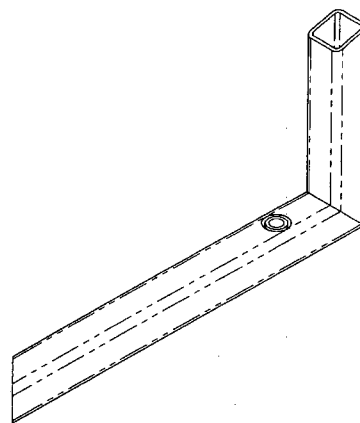
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
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NOTE: Date & initial all entries



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

| ITEM | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|---------------------------|
| 1 | X | | D3838-041 | RIB ASSY (BASKET LID, LH) |
| 2 | | X | D3838-042 | RIB ASSY (BASKET LID, RH) |
| 3 | 1 | 1 | D3759-1 | BUSHING |
| 4 | 1 | | D3838-1 | RIB |
| 5 | | 1 | D3838-2 | RIB |
| 6 | 1 | 1 | D3838-3 | RIB |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60553
BD10-715

RELEASED
08/10/08

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | MB | 08.10.08 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.10.08 | | |

| | |
|--|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D3838 | REV. A SHEET 1 OF 3 |
| TITLE RIB ASSY (BASKET LID) | SCALE NTS |
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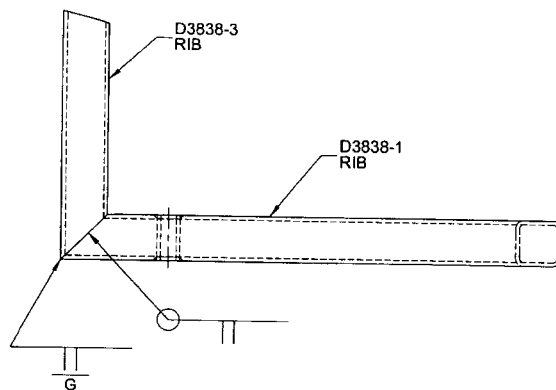
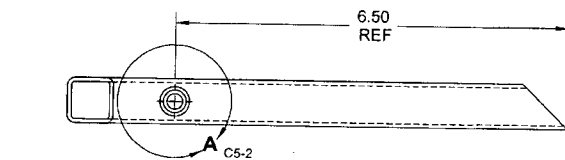
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

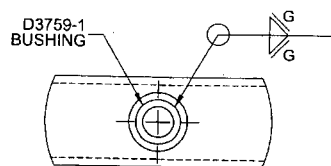
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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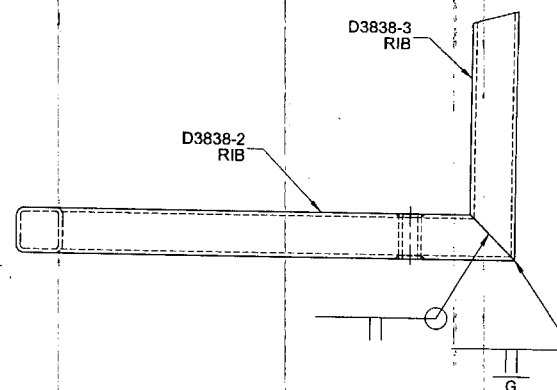
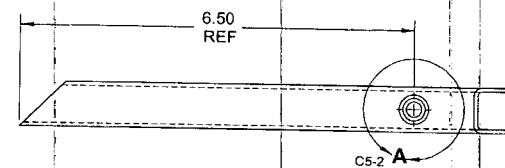
NOTE: Date & initial all entries



D3838-041 RIB ASSY (BASKET LID, LH)



DETAIL A
D2-2
D7-2 SCALE 2X



D3838-042 RIB ASSY (BASKET LID, LH)

w/o 60553

RELEASED
08/10/08

| | | | |
|------------|-----------------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>SS</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>SS</i> | D3838 | SHEET 2 OF 3 |
| APPROVED | <i>SS</i> | TITLE | SCALE |
| DE APPR. | <i>SS</i> | RIB ASSY (BASKET LID) | NTS |
| DATE | 08.10.08 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

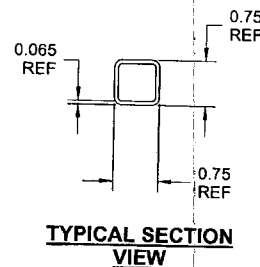
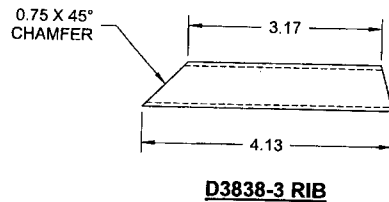
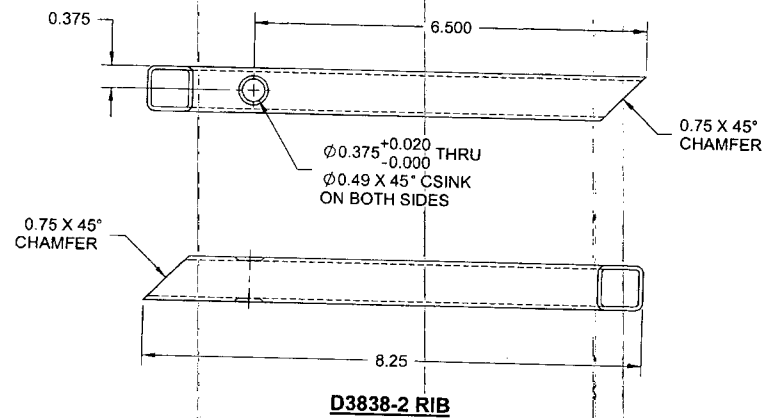
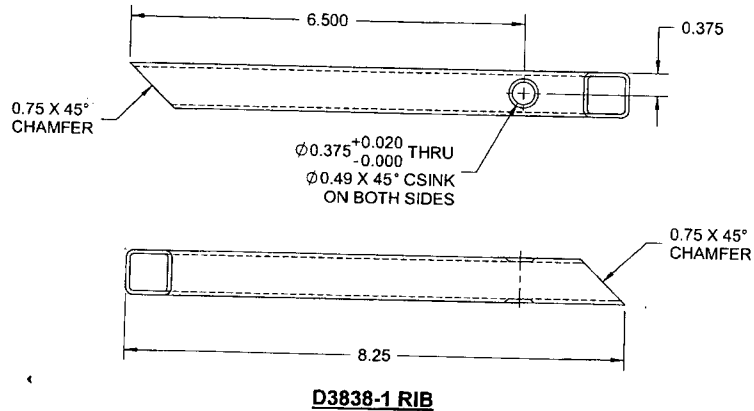
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| | | | | | | | | |
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NOTE: Date & initial all entries



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

RELEASED
26/11/84

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3838 | REV. A |
| MFG. APPR. | | TITLE | SHEET 3 OF 3 |
| APPROVED | | RIB ASSY (BASKET LID) | SCALE |
| DE APPR. | | | NTS |
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wlb-60583

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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